

Work Order ID 74146

Monday, September 26, 2011 8:58:30 AM



Page 1

Item ID:	D4034-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fwd Upper Rib Assembly					
Start Date:	9/27/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	10/7/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-09-26</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4034	B								

100	Weld per dwg A/R S.S. rod Batch:	0.00							
	<u>M115778</u>								
Large Fab	Memo	0.00							
Large Fab	1- Assemble ribs to hoop and weld as per dwg DT9564								
	2- Weld bushing in rib as per dwg								

11/10/06 (3x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11-10-06

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

(+3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 9/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Barlet 411
Memo

0.00

Packaging

11/10/06 *(Bx)*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/11 *ME* *11-10-11*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, September 26, 2011 8:58:27 AM

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

1. The first group of respondents (Group 1) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

2. The second group of respondents (Group 2) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

3. The third group of respondents (Group 3) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

4. The fourth group of respondents (Group 4) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

5. The fifth group of respondents (Group 5) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

6. The sixth group of respondents (Group 6) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

7. The seventh group of respondents (Group 7) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

8. The eighth group of respondents (Group 8) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.




9. The ninth group of respondents (Group 9) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

10. The tenth group of respondents (Group 10) consisted of 100 individuals who were randomly selected from the general population of the United States. They were contacted by mail and asked to participate in the study.

Required Date: 10/7/2011

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VRF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4034-1  Rib		Manufactured	No			100	Each	4.0000	1	3		11/10/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				4					
					69014			4					
✓ D4034-5  Rib		Manufactured	No			100	Each	5.0000	1	3		11/10/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					67339			1					
					72498			1					
				WA006				3					
					70343			3					
✓ D2327-3  Spacer Bushing		Manufactured	No			100	Each	24.0000	1	3		11/10/06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				24					
					71971			1					
					72296			3					
					72963			20					

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, September 26, 2011 8:58:27 AM

Work Order ID: 74146



Parent Item: D4034-043



Parent Item Name: Fwd Upper Rib Assembly

Start Date: 9/27/2011

Required Date: 10/7/2011

Start Qty: 3.00

Required Qty: 3.00

✓ D4021-7

Manufactured No

100

Each

11.0000

1

3



Hoop



BY 11/10/06

Location

Loc Qty

Loc Code

WA005

11

72252

11

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

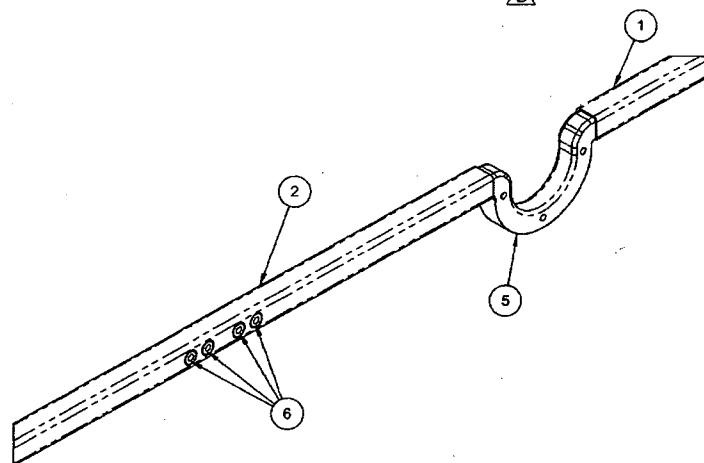
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

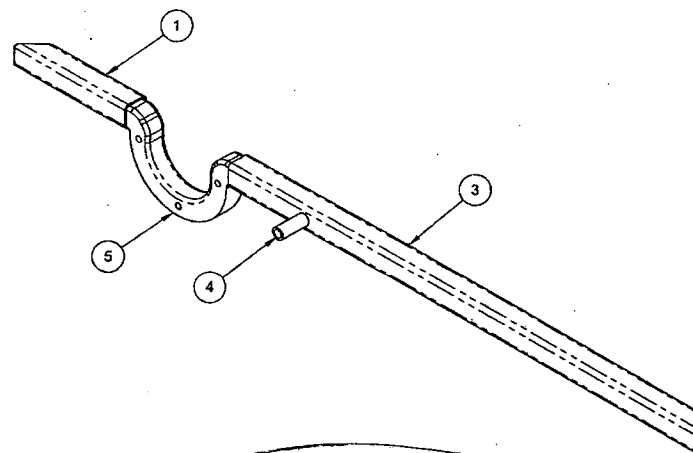
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18
MB

#74146

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	IS	DRAWING NO.	REV. B
MFG. APPR.	MB	D4034	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

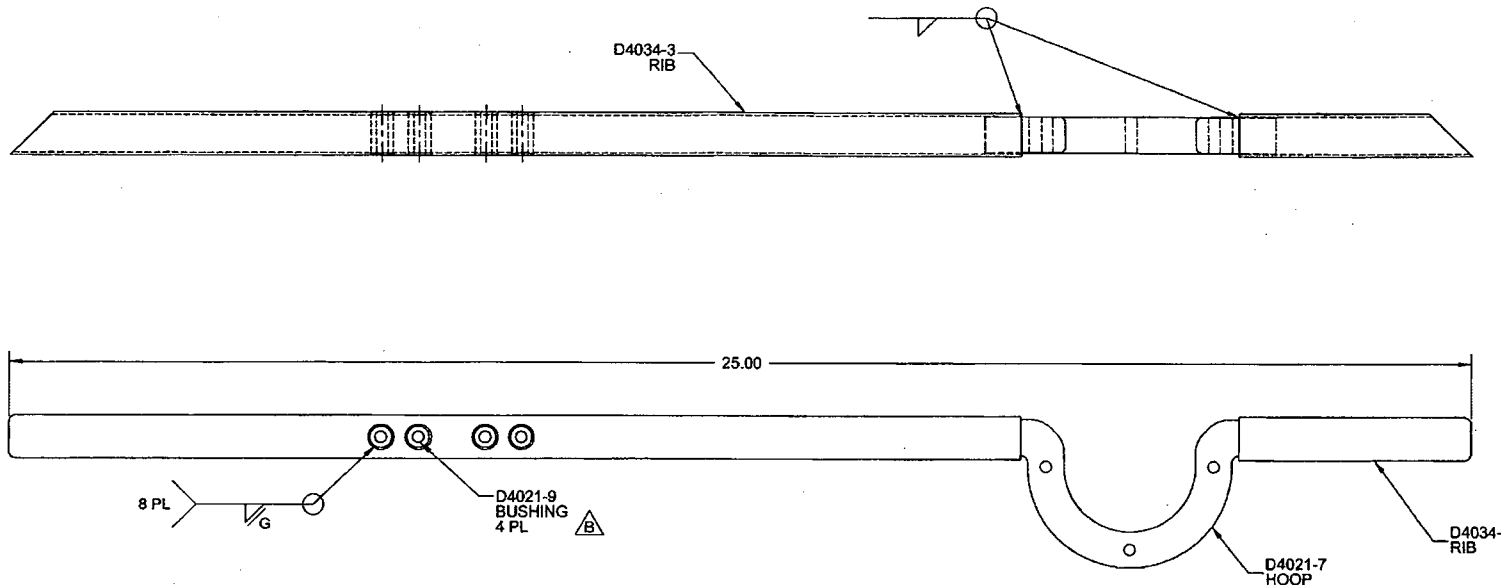
C

B

B

A

A



D4034-041 AFT UPPER RIB ASSY B

RELEASED
2011-01-18

74146

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO. D4034	REV. B
MFG. APPR.	JS	SHEET 2 OF 4	
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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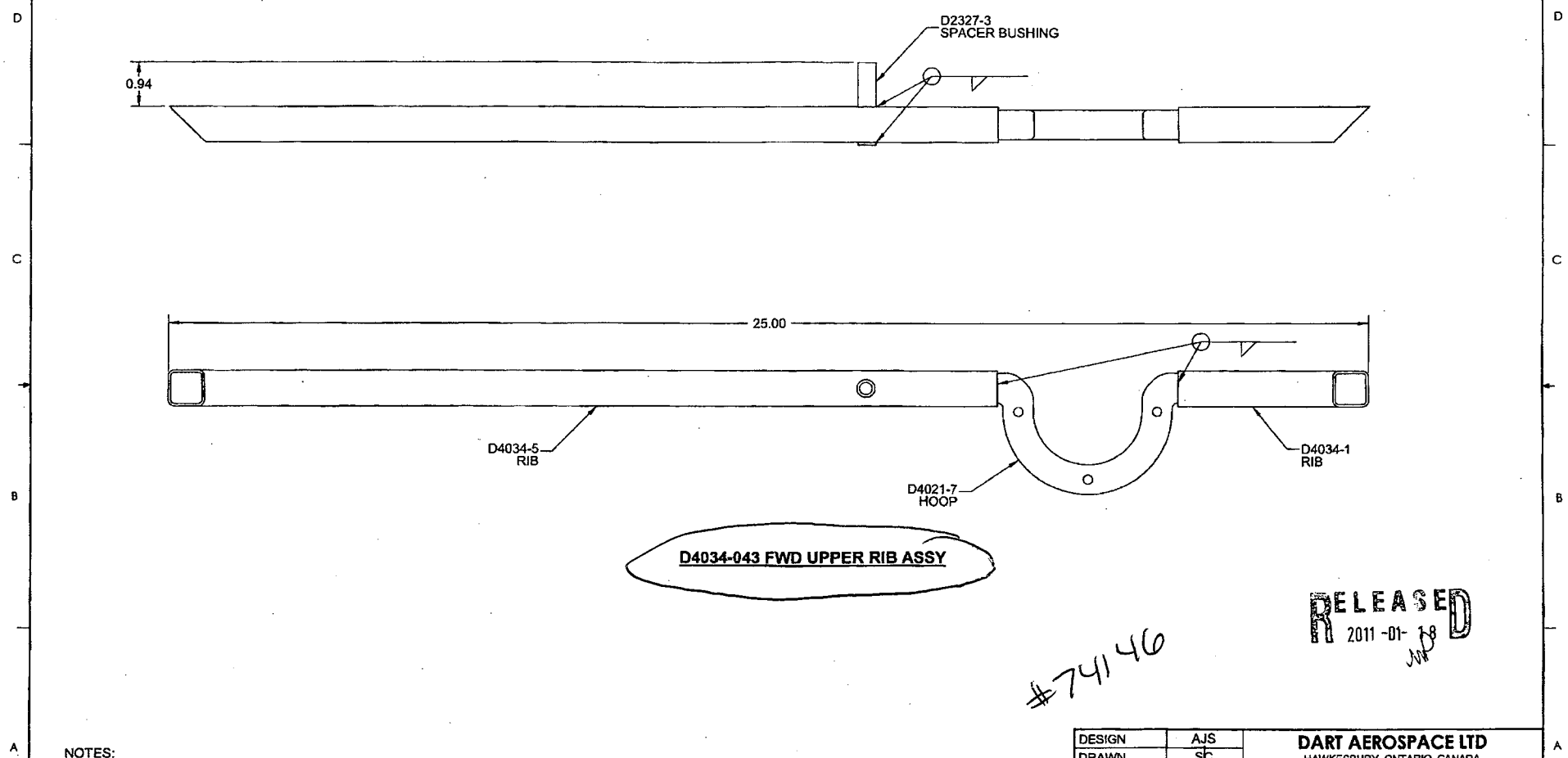
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
2011-01-18
JWP

#74146

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	IS	D4034	SHEET 3 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DATE	10.12.20		

8 7 6 5 4 3 2 1

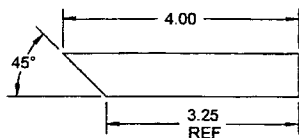
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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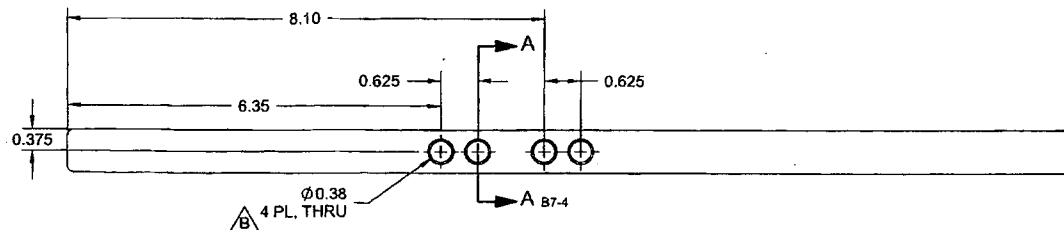


D4034-1 RIB

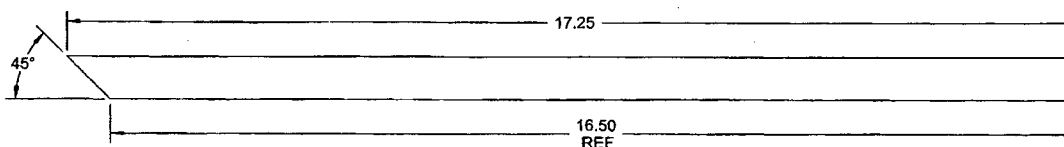
BREAK EDGE
0.030 X 45°
TYP



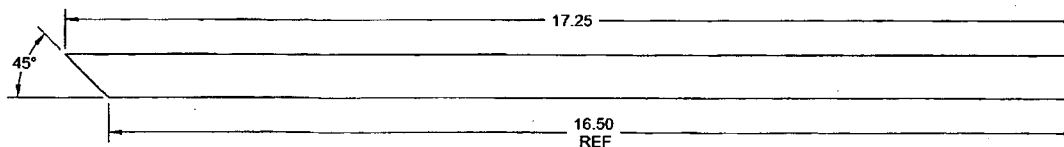
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

74146

RELEASED
2011-01-10

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE NTS	
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